Work Order ID 77920

Thursday, December 22, 2011 1:52:36 PM

77920

Item ID: D3876-3

Revision ID:

Item Name: Protector - Fwd Wall

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 12/22/2011 **Start Qty:** 2.00 *2*

Required Date: 1/6/2012 **Req'd Qty:** 2.00 *2*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** 1-12-22 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3876	A

100

100
Waterjet

FLOW CNC Waterjet

FLOW WATER JET — 0.00

Memo — 0.00

1-Cut as per Dwg D3876Dwg Rev: A Prog Rev: A 2-Deburr if necessary

B 12-1-5 ______ ______ (2)

110

110
QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB — 0.00

Memo — 0.00

B 12-1-5 ______ ______

120

120
QC

Quality Control

QC8- Inspect parts - second check — 0.00

Memo — 0.00

N 12 01 06 (2)

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W/O:	WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 77920 *77920*

Thursday, December 22, 2011 1:52:36 PM

Item ID: D3876-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Protector - Fwd Wall

Start Date: 12/22/2011 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 1/6/2012 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location:______ Memo	0.00 0.00				12/1/16			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					12/1/17		

12-01-17 ②

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 22, 2011 1:52:41 PM

Work Order ID: 77920 *77920*

Parent Item: D3876-3 *D3876-3*

Parent Item Name: Protector - Fwd Wall

Start Date: 12/22/2011 **Required Date:** 1/6/2012

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,733.665	3.86	8.126316			

MLEXS.125-F60029-04 ** 12/12/-1 -5

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
MAT019	2733.665	
115261	77.665	
119937	2656	

119937

(2)

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	77920
Description: Protector – Fwd Wall	Part Number:	D3876-3
Inspection Dwg: D3876 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.43	+/-0.030	3.43	[illegible]		T BCl	
11.05	+/-0.030	11.05	[illegible]		T	
18.69	+/-0.030	18.69	[illegible]		T	
25.86	+/-0.030	25.86	[illegible]		T	
25.34	+/-0.030	25.34	[illegible]		T	
21.86	+/-0.030	21.86	[illegible]		T	
7.84	+/-0.030	7.84	[illegible]		T	
5.40	+/-0.030	5.40	[illegible]		T	
4.15	+/-0.030	4.15	[illegible]		T	
0.35	+/-0.030	.328	[illegible]		V	
0.125	+/-0.010	.130	[illegible]		V	
1.84	+/-0.030	1.84	[illegible]		T	

Measured by:	IB	Audited by:	[signature]	Prototype Approval:	N/A
Date:	12-1-5	Date:	12.01.06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ [signature]	[signature]

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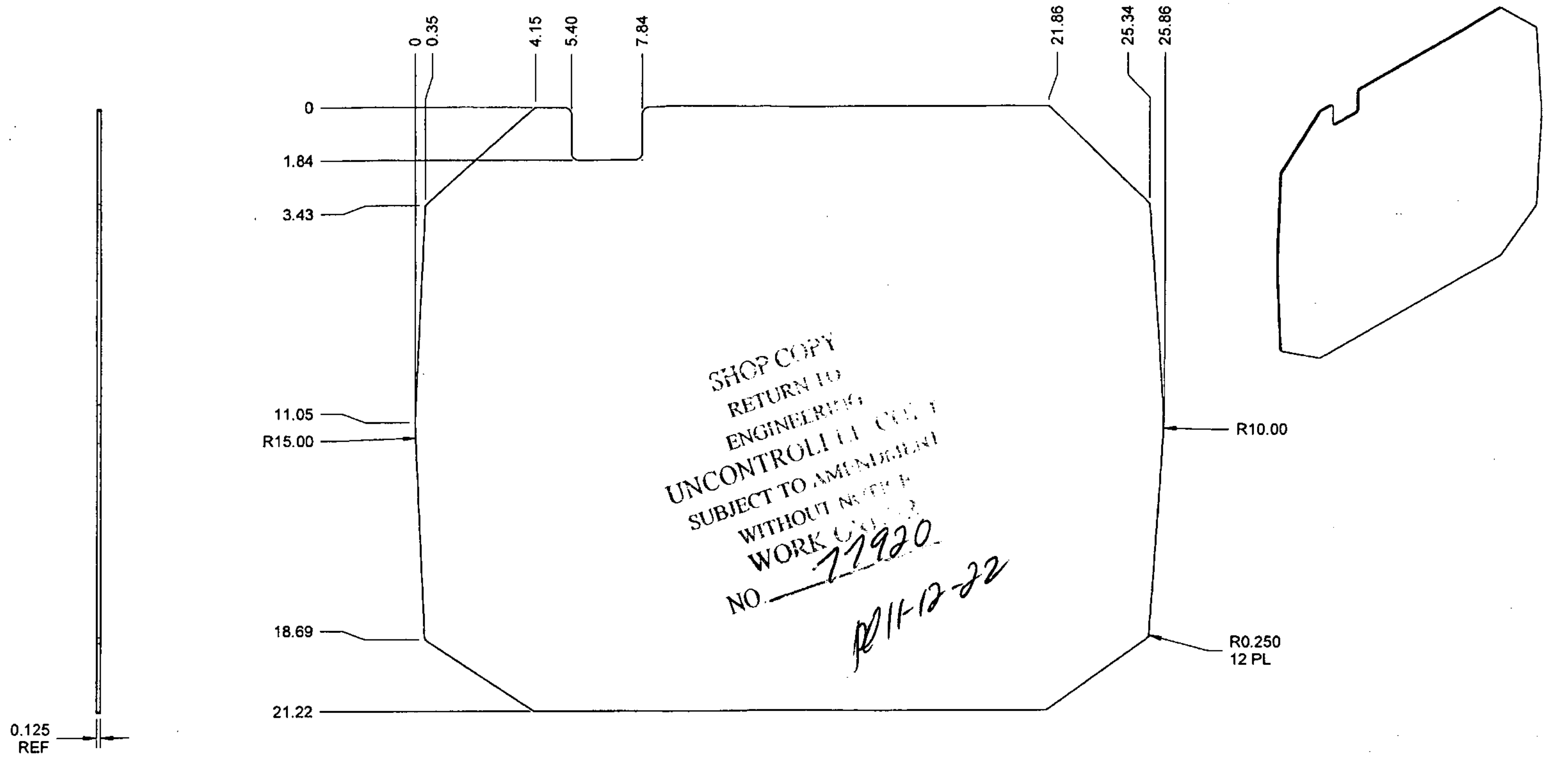
W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77920
11-12-22

D3876-3 PROTECTOR - FORWARD WALL
(TEXTURED SIDE SHOWN)

RELEASED

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 2.83 lbs
8) CHECK PER TEMPLATE DT8925

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	PH	DRAWING NO. D3876 — REV. A — SHEET 2 OF 7
MFG. APPR.		
APPROVED		TITLE BAGGAGE PROTECTOR — SCALE NTS
DE APPR.		
DATE	09.04.02	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ________________ **PAR #:** ______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE